



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

U/R

SAD

12-10-A

D119-646-243
Job Sheet OH184942



Part No: D119-646-243

Job Qty: 1 ea

Part Name: AW119 Repl. Skidtube with Heavy Duty Wearplates, Float Compatible -Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/19/18

Job Tracking No: RA438

Due Date: 10/26/18

Created By: Michelle Gagnon-Donovan

Type: Rework - OH

Description: SN: S095015

Note: URF# 18-789 DWG IIN-D119-646 REV D, D3905-045 REV E SHEETS 4,5, 7-14 IPP RevA: New issue DD verified by:EC IPP REVB 12.11.05 (DEOD3905-B-1)(ecn 12-675) DD verf:JLM IPP REV:C 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:D 15.01.19 AS PER ECN-14-628 DD verf:JLM IPP REV:E 16.11.02 chg as per D3905 revD(DEO) DD verf:JLM IPP REV:F 17.05.19 as per dwg D3905 rev.e DD verf:JFS

Ship Via:

Bill of Materials

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/26/18	0.00	0.00	Start Up Skidtubes-1		MLG
100	Skidtubes	1 pcs		10/26/18	0.00	0.00	Skidtubes-1		MLG
227	HandFinish	1 pcs		10/26/18	0.00	1.05	HandFinish2		
240	SprayPaint	1 pcs		10/26/18	0.00	0.56	Spray Paint		AR 18-10-31
245	QC	1 pcs		10/26/18	0.00	0.00	QC14		
250	HandFinish	1 pcs		10/26/18	0.00	1.05	HandFinish4		
260	QC	1 pcs		10/26/18	0.00	0.00	QC5		
270	HandFinish	1 pcs		10/26/18	0.00	1.49	HandFinish4		
280	QC	1 pcs		10/26/18	0.00	0.00	QC5		
285	HandFinish	1 pcs		10/26/18	0.00	1.05	HandFinish3		18-10-31
286	QC	1 pcs		10/26/18	0.00	0.00	QC5		NOV 01 2018 68
288	DC	1 pcs		10/26/18	0.00	0.00	DC		21 9-89
290	Packaging	1 pcs		10/26/18	0.00	0.00	Packaging3-1		9-89 NOV 01 2018
300	QC21-FG	1 Ea		10/26/18	0.00	0.00	QC21		DAG NOV 01 2018

Part Op 100 - Drill holes as per DSI 9734 Rev. D - DO NOT INSTALL CROSSBOLT SPACERS

Descriptions: 227 - Pressure Wash per QSI005 4.3

240 - Spray Painting per QSI005 4.2 *****AS PER DEO DETAIL "F" NOTE 8, SHEET 8 MASK THIS AREA, DO NOT APPLY PRIMER OR PAINT***** PRIME AS PER DWG AND QSI 005 4.2 BATCH: 138876 PAINT WHITE AS PER DWG AND QSI 005 4.2 BATCH: 138956

245 - QC14- Inspect Spray Paint

250 - Assemble as per dwg 1-Install inserts as per Dwg D3905.

260 - QC5- Inspect part completeness to step on W/O

270 - 1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 2- install plugs assembly as per dwg. 3 -Inspect for foreign objects as per QSI 024 4 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 5 -Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____

6- Install (2)D5101-041 and (1) D5101-047 as per dwg by using DT10117

280 - QC5- Inspect part completeness to step on W/O

285 - Wing Walk as per dwg QSI005 4.4 Batch _____

286 - QC5- Inspect part completeness to step on W/O

288 - Document Control Photocopy bluefile & type labels per PPP D119-646-243 CHG 005

290 - Identify as per dwg & Stock Location: _____

300 - QC21- Final Inspection - Work Order Release

14700 Dartmouth Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1-813-632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DAKI
AEROSPACE

Container No: S120402



Part: D119-646-243

Job No: OH184942

Serial No/Batch: S120402

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 15/10/2018-16/10/2018-17/10/2018-18/10/2018-19/10/2018-20/10/2018-21/10/2018-22/10/2018-23/10/2018-24/10/2018-25/10/2018-26/10/2018-27/10/2018-28/10/2018-29/10/2018-30/10/2018-31/10/2018-01/11/2018-02/11/2018-03/11/2018-04/11/2018-05/11/2018-06/11/2018-07/11/2018-08/11/2018-09/11/2018-10/11/2018-11/11/2018-12/11/2018-01/12/2018-02/12/2018-03/12/2018-04/12/2018-05/12/2018-06/12/2018-07/12/2018-08/12/2018-09/12/2018-10/12/2018-11/12/2018-12/12/2018-01/01/2019-02/01/2019-03/01/2019-04/01/2019-05/01/2019-06/01/2019-07/01/2019-08/01/2019-09/01/2019-10/01/2019-11/01/2019-12/01/2019-01/02/2020-02/02/2020-03/02/2020-04/02/2020-05/02/2020-06/02/2020-07/02/2020-08/02/2020-09/02/2020-10/02/2020-11/02/2020-12/02/2020-01/03/2021-02/03/2021-03/03/2021-04/03/2021-05/03/2021-06/03/2021-07/03/2021-08/03/2021-09/03/2021-10/03/2021-11/03/2021-12/03/2021-01/04/2022-02/04/2022-03/04/2022-04/04/2022-05/04/2022-06/04/2022-07/04/2022-08/04/2022-09/04/2022-10/04/2022-11/04/2022-12/04/2022-01/05/2023-02/05/2023-03/05/2023-04/05/2023-05/05/2023-06/05/2023-07/05/2023-08/05/2023-09/05/2023-10/05/2023-11/05/2023-12/05/2023-01/06/2024-02/06/2024-03/06/2024-04/06/2024-05/06/2024-06/06/2024-07/06/2024-08/06/2024-09/06/2024-10/06/2024-11/06/2024-12/06/2024-01/07/2025-02/07/2025-03/07/2025-04/07/2025-05/07/2025-06/07/2025-07/07/2025-08/07/2025-09/07/2025-10/07/2025-11/07/2025-12/07/2025-01/08/2026-02/08/2026-03/08/2026-04/08/2026-05/08/2026-06/08/2026-07/08/2026-08/08/2026-09/08/2026-10/08/2026-11/08/2026-12/08/2026-01/09/2027-02/09/2027-03/09/2027-04/09/2027-05/09/2027-06/09/2027-07/09/2027-08/09/2027-09/09/2027-10/09/2027-11/09/2027-12/09/2027-01/10/2028-02/10/2028-03/10/2028-04/10/2028-05/10/2028-06/10/2028-07/10/2028-08/10/2028-09/10/2028-10/10/2028-11/10/2028-12/10/2028-01/11/2029-02/11/2029-03/11/2029-04/11/2029-05/11/2029-06/11/2029-07/11/2029-08/11/2029-09/11/2029-10/11/2029-11/11/2029-12/11/2029-01/12/2030-02/12/2030-03/12/2030-04/12/2030-05/12/2030-06/12/2030-07/12/2030-08/12/2030-09/12/2030-10/12/2030-11/12/2030-12/12/2030-01/01/2031-02/01/2031-03/01/2031-04/01/2031-05/01/2031-06/01/2031-07/01/2031-08/01/2031-09/01/2031-10/01/2031-11/01/2031-12/01/2031-01/02/2032-02/02/2032-03/02/2032-04/02/2032-05/02/2032-06/02/2032-07/02/2032-08/02/2032-09/02/2032-10/02/2032-11/02/2032-12/02/2032-01/03/2033-02/03/2033-03/03/2033-04/03/2033-05/03/2033-06/03/2033-07/03/2033-08/03/2033-09/03/2033-10/03/2033-11/03/2033-12/03/2033-01/04/2034-02/04/2034-03/04/2034-04/04/2034-05/04/2034-06/04/2034-07/04/2034-08/04/2034-09/04/2034-10/04/2034-11/04/2034-12/04/2034-01/05/2035-02/05/2035-03/05/2035-04/05/2035-05/05/2035-06/05/2035-07/05/2035-08/05/2035-09/05/2035-10/05/2035-11/05/2035-12/05/2035-01/06/2036-02/06/2036-03/06/2036-04/06/2036-05/06/2036-06/06/2036-07/06/2036-08/06/2036-09/06/2036-10/06/2036-11/06/2036-12/06/2036-01/07/2037-02/07/2037-03/07/2037-04/07/2037-05/07/2037-06/07/2037-07/07/2037-08/07/2037-09/07/2037-10/07/2037-11/07/2037-12/07/2037-01/08/2038-02/08/2038-03/08/2038-04/08/2038-05/08/2038-06/08/2038-07/08/2038-08/08/2038-09/08/2038-10/08/2038-11/08/2038-12/08/2038-01/09/2039-02/09/2039-03/09/2039-04/09/2039-05/09/2039-06/09/2039-07/09/2039-08/09/2039-09/09/2039-10/09/2039-11/09/2039-12/09/2039-01/10/2040-02/10/2040-03/10/2040-04/10/2040-05/10/2040-06/10/2040-07/10/2040-08/10/2040-09/10/2040-10/10/2040-11/10/2040-12/10/2040-01/11/2041-02/11/2041-03/11/2041-04/11/2041-05/11/2041-06/11/2041-07/11/2041-08/11/2041-09/11/2041-10/11/2041-11/11/2041-12/11/2041-01/12/2042-02/12/2042-03/12/2042-04/12/2042-05/12/2042-06/12/2042-07/12/2042-08/12/2042-09/12/2042-10/12/2042-11/12/2042-12/12/2042-01/01/2043-02/01/2043-03/01/2043-04/01/2043-05/01/2043-06/01/2043-07/01/2043-08/01/2043-09/01/2043-10/01/2043-11/01/2043-12/01/2043-01/02/2044-02/02/2044-03/02/2044-04/02/2044-05/02/2044-06/02/2044-07/02/2044-08/02/2044-09/02/2044-10/02/2044-11/02/2044-12/02/2044-01/03/2045-02/03/2045-03/03/2045-04/03/2045-05/03/2045-06/03/2045-07/03/2045-08/03/2045-09/03/2045-10/03/2045-11/03/2045-12/03/2045-01/04/2046-02/04/2046-03/04/2046-04/04/2046-05/04/2046-06/04/2046-07/04/2046-08/04/2046-09/04/2046-10/04/2046-11/04/2046-12/04/2046-01/05/2047-02/05/2047-03/05/2047-04/05/2047-05/05/2047-06/05/2047-07/05/2047-08/05/2047-09/05/2047-10/05/2047-11/05/2047-12/05/2047-01/06/2048-02/06/2048-03/06/2048-04/06/2048-05/06/2048-06/06/2048-07/06/2048-08/06/2048-09/06/2048-10/06/2048-11/06/2048-12/06/2048-01/07/2049-02/07/2049-03/07/2049-04/07/2049-05/07/2049-06/07/2049-07/07/2049-08/07/2049-09/07/2049-10/07/2049-11/07/2049-12/07/2049-01/08/2050-02/08/2050-03/08/2050-04/08/2050-05/08/2050-06/08/2050-07/08/2050-08/08/2050-09/08/2050-10/08/2050-11/08/2050-12/08/2050-01/09/2051-02/09/2051-03/09/2051-04/09/2051-05/09/2051-06/09/2051-07/09/2051-08/09/2051-09/09/2051-10/09/2051-11/09/2051-12/09/2051-01/10/2052-02/10/2052-03/10/2052-04/10/2052-05/10/2052-06/10/2052-07/10/2052-08/10/2052-09/10/2052-10/10/2052-11/10/2052-12/10/2052-01/11/2053-02/11/2053-03/11/2053-04/11/2053-05/11/2053-06/11/2053-07/11/2053-08/11/2053-09/11/2053-10/11/2053-11/11/2053-12/11/2053-01/12/2054-02/12/2054-03/12/2054-04/12/2054-05/12/2054-06/12/2054-07/12/2054-08/12/2054-09/12/2054-10/12/2054-11/12/2054-12/12/2054-01/01/2055-02/01/2055-03/01/2055-04/01/2055-05/01/2055-06/01/2055-07/01/2055-08/01/2055-09/01/2055-10/01/2055-11/01/2055-12/01/2055-01/02/2056-02/02/2056-03/02/2056-04/02/2056-05/02/2056-06/02/2056-07/02/2056-08/02/2056-09/02/2056-10/02/2056-11/02/2056-12/02/2056-01/03/2057-02/03/2057-03/03/2057-04/03/2057-05/03/2057-06/03/2057-07/03/2057-08/03/2057-09/03/2057-10/03/2057-11/03/2057-12/03/2057-01/04/2058-02/04/2058-03/04/2058-04/04/2058-05/04/2058-06/04/2058-07/04/2058-08/04/2058-09/04/2058-10/04/2058-11/04/2058-12/04/2058-01/05/2059-02/05/2059-03/05/2059-04/05/2059-05/05/2059-06/05/2059-07/05/2059-08/05/2059-09/05/2059-10/05/2059-11/05/2059-12/05/2059-01/06/2060-02/06/2060-03/06/2060-04/06/2060-05/06/2060-06/06/2060-07/06/2060-08/06/2060-09/06/2060-10/06/2060-11/06/2060-12/06/2060-01/07/2061-02/07/2061-03/07/2061-04/07/2061-05/07/2061-06/07/2061-07/07/2061-08/07/2061-09/07/2061-10/07/2061-11/07/2061-12/07/2061-01/08/2062-02/08/2062-03/08/2062-04/08/2062-05/08/2062-06/08/2062-07/08/2062-08/08/2062-09/08/2062-10/08/2062-11/08/2062-12/08/2062-01/09/2063-02/09/2063-03/09/2063-04/09/2063-05/09/2063-06/09/2063-07/09/2063-08/09/2063-09/09/2063-10/09/2063-11/09/2063-12/09/2063-01/10/2064-02/10/2064-03/10/2064-04/10/2064-05/10/2064-06/10/2064-07/10/2064-08/10/2064-09/10/2064-10/10/2064-11/10/2064-12/10/2064-01/11/2065-02/11/2065-03/11/2065-04/11/2065-05/11/2065-06/11/2065-07/11/2065-08/11/2065-09/11/2065-10/11/2065-11/11/2065-12/11/2065-01/12/2066-02/12/2066-03/12/2066-04/12/2066-05/12/2066-06/12/2066-07/12/2066-08/12/2066-09/12/2066-10/12/2066-11/12/2066-12/12/2066-01/01/2067-02/01/2067-03/01/2067-04/01/2067-05/01/2067-06/01/2067-07/01/2067-08/01/2067-09/01/2067-10/01/2067-11/01/2067-12/01/2067-01/02/2068-02/02/2068-03/02/2068-04/02/2068-05/02/2068-06/02/2068-07/02/2068-08/02/2068-09/02/2068-10/02/2068-11/02/2068-12/02/2068-01/03/2069-02/03/2069-03/03/2069-04/03/2069-05/03/2069-06/03/2069-07/03/2069-08/03/2069-09/03/2069-10/03/2069-11/03/2069-12/03/2069-01/04/2070-02/04/2070-03/04/2070-04/04/2070-05/04/2070-06/04/2070-07/04/2070-08/04/2070-09/04/2070-10/04/2070-11/04/2070-12/04/2070-01/05/2071-02/05/2071-03/05/2071-04/05/2071-05/05/2071-06/05/2071-07/05/2071-08/05/2071-09/05/2071-10/05/2071-11/05/2071-12/05/2071-01/06/2072-02/06/2072-03/06/2072-04/06/2072-05/06/2072-06/06/2072-07/06/2072-08/06/2072-09/06/2072-10/06/2072-11/06/2072-12/06/2072-01/07/2073-02/07/2073-03/07/2073-04/07/2073-05/07/2073-06/07/2073-07/07/2073-08/07/2073-09/07/2073-10/07/2073-11/07/2073-12/07/2073-01/08/2074-02/08/2074-03/08/2074-04/08/2074-05/08/2074-06/08/2074-07/08/2074-08/08/2074-09/08/2074-10/08/2074-11/08/2074-12/08/2074-01/09/2075-02/09/2075-03/09/2075-04/09/2075-05/09/2075-06/09/2075-07/09/2075-08/09/2075-09/09/2075-10/09/2075-11/09/2075-12/09/2075-01/10/2076-02/10/2076-03/10/2076-04/10/2076-05/10/2076-06/10/2076-07/10/2076-08/10/2076-09/10/2076-10/10/2076-11/10/2076-12/10/2076-01/11/2077-02/11/2077-03/11/2077-04/11/2077-05/11/2077-06/11/2077-07/11/2077-08/11/2077-09/11/2077-10/11/2077-11/11/2077-12/11/2077-01/12/2078-02/12/2078-03/12/2078-04/12/2078-05/12/2078-06/12/2078-07/12/2078-08/12/2078-09/12/2078-10/12/2078-11/12/2078-12/12/2078-01/01/2079-02/01/2079-03/01/2079-04/01/2079-05/01/2079-06/01/2079-07/01/2079-08/01/2079-09/01/2079-10/01/2079-11/01/2079-12/01/2079-01/02/2080-02/02/2080-03/02/2080-04/02/2080-05/02/2080-06/02/2080-07/02/2080-08/02/2080-09/02/2080-10/02/2080-11/02/2080-12/02/2080-01/03/2081-02/03/2081-03/03/2081-04/03/2081-05/03/2081-06/03/2081-07/03/2081-08/03/2081-09/03/2081-10/03/2081-11/03/2081-12/03/2081-01/04/2082-02/04/2082-03/04/2082-04/04/2082-05/04/2082-06/04/2082-07/04/2082-08/04/2082-09/04/2082-10/04/2082-11/04/2082-12/04/2082-01/05/2083-02/05/2083-03/05/2083-04/05/2083-05/05/2083-06/05/2083-07/05/2083-08/05/2083-09/05/2083-10/05/2083-11/05/2083-12/05/2083-01/06/2084-02/06/2084-03/06/2084-04/06/2084-05/06/2084-06/06/2084-07/06/2084-08/06/2084-09/06/2084-10/06/2084-11/06/2084-12/06/2084-01/07/2085-02/07/2085-03/07/2085-04/07/2085-05/07/2085-06/07/2085-07/07/2085-08/07/2085-09/07/2085-10/07/2085-11/07

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D119-646-243	AW119 Repl. Skidtube with Heavy Duty Wearplates, Float Compatible -Fits LH or RH	1 Ea (1 ea)	90-Start up Operation	
ALS4-1032-130	Rivnut	10 Ea (10 ea)	250- HandFinish	
ALS4-1032-225	Rivnut	1 Ea (1 ea)	270- HandFinish	
AN3C46A	Bolt	4 Ea (4 ea)	270- HandFinish	
AN3C50A	Bolt	4 Ea (4 ea)	270- HandFinish	
AN3C5A	Bolt	12 Ea (12 ea)	270- HandFinish	
AN4C46A	Bolt	3 Ea (3 ea)	270- HandFinish	
D2855-3	Cap	1 Ea (1 ea)	270- HandFinish	
D3411-3	Washer	16 Ea (16 ea)	270- HandFinish	
D3672-1	Washer, Phenolic	2 Ea (2 ea)	270- HandFinish	
D3847-1	Wearpad	1 Ea (1 ea)	270- HandFinish	
D3847-11	Wearpad	1 Ea (1 ea)	270- HandFinish	
D3849-045	Aft Heavy-Duty Wearplate, Float Skid Compatible	1 Ea (1 ea)	270- HandFinish	
D3849-047	Fwd Heavy-Duty Wearplate, Float Skid Compatible	1 Ea (1 ea)	270- HandFinish	
D3904-1	Washer	16 Ea (16 ea)	270- HandFinish	
D5101-041	Crossbolt Spacer Assembly	2 Ea (2 ea)	270- HandFinish	
D5101-047	Crossbolt Spacer Assembly	1 Ea (1 ea)	270- HandFinish	
D5101-3	Insert	6 Ea (6 ea)	270- HandFinish	
D5101-5	Insert	6 Ea (6 ea)	270- HandFinish	
MS21043-3	Nut	8 Ea (8 ea)	270- HandFinish	
MS21043-4	Nut	3 Ea (3 ea)	270- HandFinish	
MS24694-C52	Screw	2 Ea (2 ea)	270- HandFinish	
NAS1149C0332R	Washer	8 Ea (8 ea)	270- HandFinish	
NAS1149D0416J	Washer	3 Ea (3 ea)	270- HandFinish	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D119-646-243	1	0	0
250-HandFinish	ALS4-1032-130	10	11,813	0
270-HandFinish	ALS4-1032-225	1	1,815	0
	AN3C46A	4	92	0
	AN3C50A	4	189	0
	AN3C5A	12	1,694	0
	AN4C46A	3	210	0
	D2855-3	1	4	0
	D3411-3	16	42	0
	D3672-1	2	956	0
	D3847-1	1	34	0
	D3847-11	1	12	0
	D3849-045	1	2	0
	D3849-047	1	1	0
	D3904-1	16	56	0
	D5101-041	2	2	0
	D5101-047	1	4	0
	D5101-3	6	9	0
	D5101-5	6	6	0
	MS21043-3	8	1,175	0
	MS21043-4	3	1,106	0
	MS24694-C52	2	134	0
	NAS1149C0332R	8	3,710	0
	NAS1149D0416J	3	2,275	0
Part Specifications				
Specifications could not be found.				

Plex 10/19/18 11:18 AM Dart.Gagnon.Michelle

Inspection Sheet Complete RA438

Customer QA Ref #

0

Part Number	Original Batch / Serial # / Ctrl #	Original Revision #	Quantity	Part Complete	Rev/CHG Current	New Paperwork	New Labels	Disposition	Original Container #	New (Receiving) Serial #	New Job #	Work order instructions
D119-646-243	S095015		1	☒ yes	☒ es	☒ es	☒ es	CUSTOMER SUPPLIED	S095015	S119093		Customer returning D119-646-243 S095015 at Dart to drill holes for hoist guard. During receiving inspection, paint damage on tube was notice. Additional rework to deliver tube back to the customer will be needed as followed • Scuff aft section of tube and re paint (apply Alodine and primer if necessary) • Scuff and re paint aft cap. • Apply wing walk as per drawing. • Replace used hardware. Return to customer using original serial number at CHG005 Add new labels and paper work.
D119-646-243	S089688		1	☒ yes	☒ es	☒ es	☒ es	CUSTOMER SUPPLIED	S089688	S119094		Customer returning D119-646-243 S089688 at Dart to drill holes for hoist guard. During receiving inspection, paint damage on tube was notice. Additional rework to deliver tube back to the customer will be needed as followed • Scuff aft section of tube and re paint (apply Alodine and primer if necessary) • Scuff and re paint aft cap. • Apply wing walk as per drawing. • Replace used hardware. Return to customer using original serial number at CHG005 Add new labels and paper work.
0			0	☐ yes	☐ es	☐ es	☐ es					
0			0	☐ yes	☐ es	☐ es	☐ es					
0			0	☐ yes	☐ es	☐ es	☐ es					
0			0	☐ yes	☐ es	☐ es	☐ es					

QC Approval: AT _____

Date: 17-Oct-18 _____

Special Return/Rework Instructions:

644.4112

x8

644.4113

x8

644.4101

b18